

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024012**Date Inspected:** 25-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #19

This QA Inspector observed the following work in progress,

Flux Cored arc welding (FCAW)

Weld joint- 025, Located on Cable Bracket SA6029-001. Welder is identified as 062757. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 036, Located on Cable Bracket SA6029-001. Welder is identified as 062757. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 036, Located on Cable Bracket SA6031. Welder is identified as 062808. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

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Weld joint- 027, Located on Cable Bracket SA6030. Welder is identified as 062783. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint- 074, Located on Cable Bracket SA6530. Welder is identified as 062783. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- X 64A as per CWR no. B-CWR-2877, Located on Suspender Bracket SB22-106W. Welder is identified as 062757. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) –Repair.

Heat Straightening:

Heat Straightening being performed on Suspender Bracket identified as SB22-106W- X 64A by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Ping present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10153.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint- 003/ 007, Located on Bike path Hand rails, FS2. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint- 003, Located on Bike path Hand rails, FS18. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 001/ 004 as per WRR no. B-WR-20755, Located on Traveler Rail TR 3021 -001.

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Welder is identified as 066695/ 066734. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-Repair.

Weld joint- 001/ 002, Located on U Rib Splice plate X3305K-005. Welder is identified as 066002. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-TC-U4B-FCM-1.

Weld joint- 001/ 002, Located on U Rib Splice plate X3305K-007. Welder is identified as 066019. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-TC-U4B-FCM-1.

Flux Cored arc welding (FCAW)

Weld joint- 001/ 002, Located on U Rib Splice plate X3305K-002. Welder is identified as 201215. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint- 001/ 002, Located on U Rib Splice plate X3305K-004. Welder is identified as 067275. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

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No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
